



Dart Aerospace Ltd.
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RBEA62309
Job Sheet 170534



002064

Part No: RBEA62309

Job Qty: 1 ea

Part Name: AS350/355 Field Maintenance



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: RBEA62309 rev.12 IPP REV:A 17.12.13 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea		2/22/18			DAR001-VU		
110	Small Fab	1 pcs		2/23/18	0.00	1.00	Small Fab-9		
120	QC	1 pcs		2/23/18	0.00	0.00	QC5		DAS
130	Packaging	1 pcs		2/23/18	0.00	0.00	Packaging3-2		21
140	QC21-FG	1 Ea		2/23/18	0.00	0.00	QC21		9-8 APR 02 2018

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Install placard to wheel housing as per DWG 6-Glue foam to case and pack case 7-See note 1 for hoses

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Start up Operation	97524A032	4	259	0	0
	APP-1700-E	1	0	0	0
	RB41011	1	955	0	0
	RBE-350DAMPER 5048091	1	0	0	0
	RBE-350HYD 5051027	1	0	0	0
	RBE-350INCLINOMETER	1	0	0	0
	RBE-350TDRS	1	2	0	0
	RBE-350TEMP 5045008	1	0	0	0
	RBE350A93-3200-20	1	0	0	0
	RBE350A93-3205-00E	1	0	0	0
	RBE350A93-3205-00T	1	0	0	0
	RBE350A93-3300-20	1	0	0	0
	RBE350A93-3302-02	1	0	0	0
	RBE350A93-3303-02	1	0	0	0
	RBE350A93-3305-20	1	0	0	0
	RBE350A93-3307-00	1	0	0	0
	RBE350A93-3312-03	1	0	0	0
	RBE350A93-3316-20	1	0	0	0
	RBE350A93-3317-20	1	0	0	0
	RBE350A93-3400-00	1	0	0	0
	RBE350A93-3500-00	1	0	0	0
	RBE350A93-3501-20	1	0	0	0
	RBE350A94-2704-00	1	0	0	0
	RBE350A94-2706-00	1	0	0	0
	RBE350A94-2708-01	1	0	0	0
	RBE350A94-3301-00	1	0	0	0
	RBE350A94-3700-A	1	0	0	0

DAS
03
-P

RBE350A94-3700-C	1	0	0	0
RBE350A94-3701-00	1	0	0	0
RBE350A94-5201-20	1	0	0	0
RBE703A94-1130-01	1	0	0	0
RBE703A95-0505-00	1	0	0	0
RBE703A95-0508-00	1	2	0	0
RBE703A95-0520-01	1	0	0	0
RBE703A95-0520-01-11	1	0	0	0
RBE703A95-0520-01-13	1	0	0	0
RBE703A95-0520-01-15	1	0	0	0
RBEA62309-65	1	0	0	0
RBEA62309-81	1	0	0	0
RBEA62309-83	1	0	0	0
RBEA62310	1	0	0	0
RBT18025-13	1	0	0	0
RBW109-3101-58-1-1	1	0	0	0
RBW109-3101-58-2-1	1	0	0	0

Part Specifications

Specifications could not be found.

Plex 1/17/18 8:59 AM Dart.lajeunesse.marie



Container No: S056921



Part: RBEA62309

Job No: 170534

Serial No/Batch: S056921

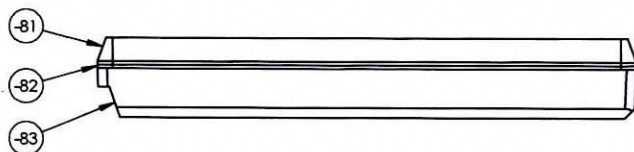
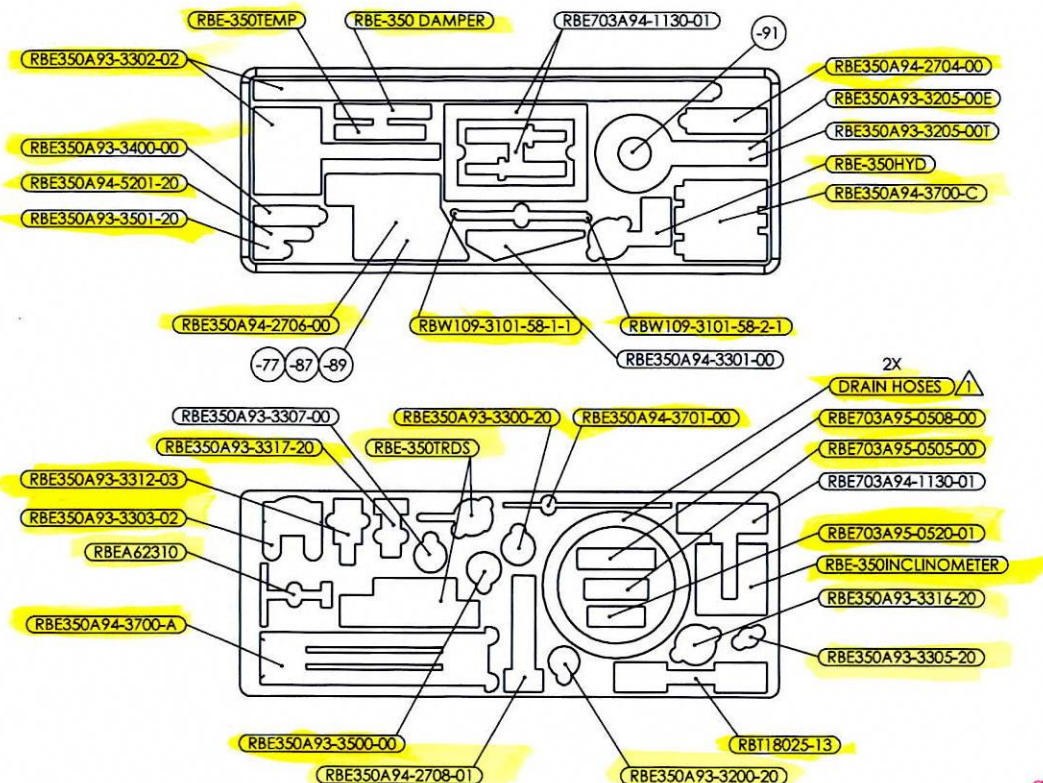
Revision: 12

Inspector:

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Date: 03/29/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-#1 REARRANGED TOP SHELF TOOLS. -#3 RECONFIGURED BOTTOM SHELF TOOL ARRANGEMENT TO BETTER FIT RED BARN TOOLS. -#5 RECONFIGURED TOP AND BOTTOM SHELF TOOL ARRANGEMENT TO BETTER FIT RED BARN TOOLS. ADDED LAMINATED LOCATOR CARD AND LANYARD COMPONENTS.	9/22/2009	WP	
2		REDRAWN TO USE HELPPRODUCTS TOOLS AND ALLOW FOR 3 DRAIN HOSES.	1/25/2010	WP	RW
2A		ADDED NEW RED BARN PHOTOS.	2/11/2010	RJC	RW
3		-#1 REARRANGED TOP SHELF TOOLS. -#3 REARRANGED BOTTOM SHELF TOOL CUSHION TO ACCOMMODATE NEW DIGITAL TORPEDO LEVEL. ADDED SECTION A-A TO CLARIFY CUT OUT FOR RBEA94-3701-00. CHD CUTOUT DEPTH FOR RBEA94-3700-A. RBEA94-5201-20 & RBEA93-3501-20. -#5 REARRANGED TOP AND BOTTOM SHELF CUSHIONS TO ACCOMMODATE NEW DIGITAL TORPEDO LEVEL. CHD CARD INFORMATION FOR LLS.	2/18/2010	RJC	
4		-#3 REARRANGED TOOL CUTOUTS. ADDED CUT OUT FOR RBEA62310. -#5 UPDATED CARD.	3/9/2010	WP	
4A		-#9 & -51 CHD QTY. FROM 3 TO 1 SET, UPDATED LAYOUT PHOTOS.	5/26/2010	RJC	
4B		-#7 & -89 ADDED ONE TO EACH QTY.	7/21/2010	WP	RW
4C		-#11 ADDED CONTAINER FOR RBEA93-3205-00-1 & RBEA93-3205-00-03 NUTS & BOLTS.	10/27/2010	WP	DW
5		-#1 DELETED CUTOUT NOTCHES FOR RBE-RDG-15.	6/20/2011	RJC	RW
6		CORRECTED DRAIN HOSE 1/N FROM RBEA93-0502-01 TO RBEA93-0520-01. -#3 CHD FOAM CUTOUTS FOR RBEA93-3500-00, RBEA93-3300-20, RBEA93-3200-20 & RBEA93-3317-20 FOR BETTER FIT. -#5 UPDATED CARD.	2/27/2012	RJC	DW
7		-#3 CHD TOOL LAYOUT. ADDED NEW DESIGN FOR DRAIN HOSES & CUTOUTS FOR INDIVIDUAL QUILLS. CHD CUTOUT FOR RBEA94-3700-A FOR TIGHTER FIT. -#5 UPDATED CARD.	1/9/2013	RJC	SE
7A		-#5 CORRECTED ITEM Q P/N FROM RBEA93-3305-02 TO RBEA93-3305-20. CHD F QTY. FROM 8 TO 1. ADDED K DRAIN HOSE QTY. 2. CHD LOCATION D1 & D2 TO D. AND X1, X2, & X3 TO X.	4/11/2013	RJC	RJC
8		-#1 CHD DIM WAS 4.75 B 4.44. -#3 CHD CUTOUT LOCATION FOR RBE350A94-3700-A. -#5 CORRECTED 1/N & TOOL DESCRIPTION TO MATCH CURRENT DRAWINGS.	10/24/2013	CFS	DW
9		-#1 CHD CUTOUT FOR RBE-350HYD (NEW GAUGE). CHD CUTOUT FOR RBE350A94-3700-C TO FIT BETTER. -#3 CHD CUTOUT FOR RBE350A94-3700-A TO SECURE TOOLS BETTER.	3/25/2014	RJC	DW
10	15-0038	UPDATED TO NEW DRAFTING STANDARDS. -#3 CHD FOAM TO ACCOMMODATE SNAP-ON INCLINOMETER. -#5 CHD CARD TO SHOW NEW TOOL LAYOUT WITH SNAP-ON INCLINOMETER.	2/11/2015	DPD	JAG
11	16-0149	-#1 ADDED DETAIL SHEET. REPLACED RBE-RDG-15 WITH RB18025-13 AND MOVED TO -#3. ADDED RBW109-3101-58-1 & RBW109-3101-58-2. CHD MATERIAL WAS 120 BLACK ETHAFOAM 220. BLACK. -#2 ADDED DETAIL SHEET. -#3 ADDED DETAIL SHEET. CHD TOOL LAYOUT. CHD DIM WAS 4X 8.64 B 3X 8.4 X 45°. DELETED DIMS. 73 (X2), 18" (X2), 1.38 (X2) & 8.75 (X4) SPHERE. AND ADDED DIMS. 78. 1.48 & 1.25. CHD FOAM WAS 120 BLACK ETHAFOAM 220. BLACK. MOVED RBE350A93-3400-00, RBE350A94-5201-20 & RBE350A93-3501-20 TO -#1. -#3 RBE-RDG-15 REPLACED W/ RB18025-13. -#5 REARRANGED TOOLS TOP AND BOTTOM. ADDED RBW109-3101-58-1. RBW109-3101-58-2. RB18025-13. -77, -87, & -89.	9/20/2016	RJC	JAG
12	17-0013	-#1 CHD DIM WAS 820 B 82. -#3 CHD DETAIL ORGANIZATION. REMOVED DIM 3X 9.88, 3X 1.38, 33.47, 2X 34.17, 7.225, 8.07, 7.13. ADDED DIM 67.75, 30.13, 5.49, 12.77, R.13, R.138, 5X R.50, 2X R.43, 6X R.13, R.50. CHD DIM WAS 10.24 B 3X 10.24. WAS 2X 34.86 B 3X 34.86. WAS 12.33 B 8.80. WAS 11.54 B 8.11. -#5 REARRANGED TOOLS ON BOTTOM SHELF. UPDATED ITEM 12 & 13 TOOL NUMBERS.	1/24/2017	SM	JAG

NOTE:

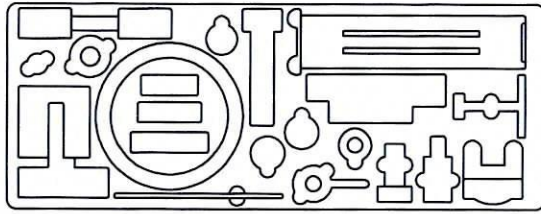
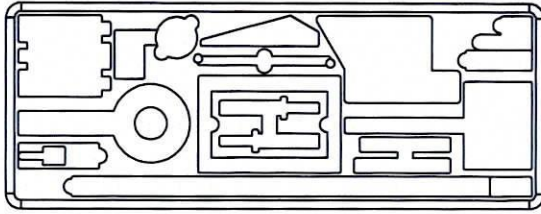
7 FT. HOSES MUST COUPLE IN CUTOUT. MIN TRIM ACCEPTABLE.

DART AEROSPACE		REV 12	
		AS350-355 FIELD MAINTENANCE KIT	
DWG NO. RBEA62309		REV 12	
MAT'L PART FINISH SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/16 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES ± 1/32	
DRAWN BY: CLOUGH CHECKED: DUERFELDT OPFS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT		1. BREAK ALL SHARP EDGES .015 X 45° OR .013R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE 1:8		DATE 9/20/2016	
SHEET 1 OF 8		USED ON MODEL AS350/355	

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WORK ORDER
NO. 170534 MJS
1801-17

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ASSY QTY	UNIT	Port #	B/O	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PQ.
1				DAMPER SPANNER WRENCH		R86-3500AMPER	1
1				HYD. ACCUMULATOR BEARING RUNOUT GAUGE		R86-3500HYD	1
1				T/R DRIVESHAFT BEARING RUNOUT GAUGE		R86-3507RDS	1
1				MGB/ROTOR BRAKE RETAINING NUT WRENCH		R86350A93-3000-20	1
1				T/R G/R INPUT FLANGE HOLDING WRENCH		R86350A93-3005-007	1
1				ENGINE O/R INPUT FLANGE HOLDING WRENCH		R86350A93-3005-00E	1
1				T/R HUB SOCKET		R86350A93-3000-20	1
1				T/R HUB LOCK WRENCH		R86350A93-3002-02	1
1				T/R BODY EXTRACTION TOOL		R86350A93-3003-02	1
1				TAIL GEARBOX WRENCH		R86350A93-3005-20	1
1				TAIL GEARBOX SEAL EXTRACTOR		R86350A93-3007-00	1
1				T/R HUB BUSHING REPLACEMENT TOOL		R86350A93-3012-03	1
1				ROTATING SHAFT REPLACEMENT WRENCH		R86350A93-3016-20	1
1				TAIL ROTOR HUB INSERT TOOL		R86350A93-3017-20	1
1				DRIVE SHAFT THIMBLE		R86350A93-3000-00	1
1				BEARING EXTRACTOR		R86350A93-3000-00	1
1				EXTRACTION TOOL HYD. PUMP PULLEY BEARING		R86350A93-3001-20	1
1				MAIN BLADE TRIM TABS TOOLS		R86703A94-1130-01	1
1				JAMMING TOOL PEDALS		R86350A94-2704-00	1
1				BRIGGING PIN SET		R86350A94-2706-00	1
1				T/R BLADE LOCK FIXTURE		R86350A94-2708-01	1
1				T/R ACCELERATOR SUPPORT		R86350A94-3001-00	1
1				SWASHPLATE BMMOBUILDING TOOL LONG SPACE		R86350A94-3700-04	1
1				SWASHPLATE BMMOBUILDING TOOL ADJUSTABLE BRACE		R86350A94-3700-0C	1
1				M/R BRIGGING TOOL		R86350A94-3701-20	1
1				CARTIDGGE, DUMMAY, FUEL		R86350A94-5201-20	1
1				ENGINE & HYDRAULIC		R86703A95-05020-01-1, -11, -13, -15	1
1				TGA DRAIN TUBE		R86703A95-0505-00	1
1				MGB DRAIN TUBE		R86703A95-0506-00	1
1				LINEAR SCALE		R8118023-13	1
1				R8E42310		R8E42310	1
1				HAMMER, STEEL		R8W109-3101-58-1-1	1
1				HAMMER, ALUMINUM		R8W109-3101-58-2-1	1
1				INCLINOMETER		R86-3500INCLINOMETER	1
1				R86-3500TEMP		R86-3500TEMP	1
6				LAMINATED CARD		01/16 X 12 CARB LANE # CL-2-C	N/S
N/S				NICKEL-PLATED BRASS		01/16 X 12 (MCMMASTER-CARR #66623K31)	N/S
N/S				COATED COPPER		03/16 X 3/8 - 1/2 (MCMMASTER-CARR #93264A21)	N/S
N/S				ALUMINUM		03/16 X 3/8 - 1/2 (MCMMASTER-CARR #3896131)	N/S
1				BUNGEE CORD		01/4 X 10M.	1
N/S				PLASTIC		PEUCAN #APP-1700-E	N/S
3 & 4				ETHAFOAM 220, BLACK		1/81 X 13-5/8 X 35-5/8 (CASE SOLUTIONS)	3 & 4
5				COSOPLAST, BLACK		5/16 X 13-5/8 X 35-5/8 (CASE SOLUTIONS)	5
6 & 7				ETHAFOAM 220, BLACK		5/16 X 13-5/8 X 35-5/8 (CASE SOLUTIONS)	6 & 7
1				NYLON		NAS 1756-12	1
1				NYLON		(MCMMASTER-CARR #718931)	1
1				POLYPROPYLENE		02/20 O.D. X 1.58H. (MCMMASTER-CARR #52747761)	1
N/S				ALUMINUM		R841011	N/S



SCALE	1:1	DATE	9/20/2016	SHEET 2 OF 8
APPROVED:	GILBERT	DESIGNED BY:	CLOUGH	
QA APPR:	LINDSAY	CHECKED:	DUFFERFELDT	
OPPS APPR:	ANDERSON	1. BREAK ALL SHARP EDGES		
		2. DIMENSIONAL LIMITS APPLY		
		3. AFTER PLATING		
		4. AFTER TOL PER		
		5. AFTER TOL PER		
		6. AFTER TOL PER		
		7. AFTER TOL PER		
		8. AFTER TOL PER		
		9. AFTER TOL PER		
		10. AFTER TOL PER		
		11. AFTER TOL PER		
		12. AFTER TOL PER		

DWG NO.	RBEA62309	REV	12
TITLE	AS350-355 FIELD MAINTENANCE KIT		

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
11	16-0149	ADDED R8W109-3101-58-1 & R8W109-3101-58-2 TO BOM. +3 R86-3500-15 REPLACED W/ R8118023	9/21/2016	RJC	JAG
12	17-0013	CHD B/O INFO WAS R86703A95-05020-01 R 86703A95-05020-01-1, -11, -13, -15 WAS R8W109-3101-58-1 R 8W109-3101-58-2 R 8W109-3101-58-2-1 CHD DESCRIPTION WAS	1/24/2017	SM	JAG

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					